



PRODUCT INFORMATION



Product Name:	IMPLAMEL ONE COAT SHEEN FINISH
Reference Number:	24-Line
Coating Type:	Modified alkyd/zinc phosphate.
Typical Uses:	General purpose, high build, fast drying “one-coat” primer/finish for structural steel-work, waste skips and similar steel fabrications. See note 1 overleaf.
Colours Available:	All British Standard and RAL shades available on Dacmix tinting schemes
Appearance Of Dried Film:	Sheen.
Volume Solids:	40% (may vary with colour).
Dry Film Thickness:	Typical: 75 microns.
Theoretical Coverage:	5.33m ² per litre at 75 microns.
Drying Time At 20°C: (Will Vary With Temperature, Air Movement etc.)	Touch Dry: 20 minutes. Firm Dry: 1 hour. Overcoat: See note 2 overleaf.
V.O.C.	550gram/litre (may vary with colour)
Packaging:	5 litre containers.
Shelf Life:	2 years or longer in unopened containers when stored under cover in good storage conditions.
Storage:	Under cover within temperature range of 5°C to 32°C.

Continued/



Surface Preparation: Preferred method is abrasive blast to ISO 8501-1 SA2.5.

Manual Clean

Chip, scrape and wire brush to remove all loose millscale, rust, etc. Degrease with Dacrylate Thinner R5.

Application: May be applied by conventional or airless spray. Up to 10% Dacrylate Thinner R5 may be added to obtain optimum spray characteristics.

Apply to an approximate wet film thickness of 190 microns to achieve 75 microns dry film thickness.

Due to the fast drying nature of this product only small areas and narrow sections can be brush applied. Apply with a full wet brush, do not attempt to 'brush out' or 'lay off'.

Note 1: This product is designed to be used on large industrial items and is not suitable for use on smaller components.

Due to the nature of the material, bag wrapping, stacking etc. should not be carried out as damage to the coating may occur.

Note 2: Should a second coat be required, allow a minimum of 4 hours drying or preferably leave overnight between coats.

The maximum over coating time is indefinite and is subject to normal good housekeeping practices for preparation and cleanliness between coats.

Clean-Up: Dacrylate Thinner R5.

Health And Safety: Please see relevant MSDS sheet.

Data sheets are issued to supply **general information** on the product but without warranty. Since conditions of service and application are beyond our control we cannot accept claims for loss, damage etc., based on this information. Dacrylate will not accept any claim for consequential or incidental damages.

Issued: July 2004

KW/DAE/WHC